

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028147**Date Inspected:** 08-Aug-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Fred Michels**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** S.A.S. Components**Summary of Items Observed:**

The Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project.

The QAI reviewed contract documents at pier 7. The QAI used approved weekly welding report submittals and cross referenced the welding and inspection status as reported with QA records to identify the overall weld status. The QAI continued filing the welding report submittals that were reviewed during the previous week. This work was in progress until the end of the shift.

The QAI was present at the Skyway Bikepath and witnessed production testing with Bleyco worker Johnny Tucker operating the stud welding machine. The QAI noted that 1/4" diameter, 1 1/4" threaded stainless steel studs are being / will be used to attach the electrical conduit piping onto the skyway bikepath panels where modifications have been made for Contract Change Order (CCO) 179. The QAI noted that the testing and welding is being monitored by the Quality Control Inspector (QCI) Fred Michels. The QAI was informed that the torque testing of the production testing is acceptable. The QAI examined the stud welds and noted that they appeared to be visually conforming to the contract requirements. The QAI made further observations of the work being performed during this shift and noted that the work appeared to be conforming to the contract requirements. See the attached photo.

The QAI made observations of welding in progress at Pier 7. The QAI noted that ABF workers Kevin Kananen, ID 6521, and Chris Bruce, ID 8901, are making Shielded Metal Arc Weld (SMAW) fillets, attaching pipe supports onto the tower head cover assembly. The QAI noted that the QCI Fred Michels is monitoring this welding. The

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QAI reviewed the available drawings / details for the pipe penetrations and noted that the work also includes welding of the dehumidification duct attachments to the tower head cover assembly. The QAI noted that the work is using Welding Procedure Specification ABF-WPS-D1.5-F1200A. The QAI made random observations of the work during this shift and noted that the welding appeared to be visually conforming to the contract requirements. The QAI noted that the work was not completed at the end of the shift. The QAI also noted that the contractor will conduct Magnetic Particle Testing (MT) of the welds when they are completed. See the attached photo.

The QAI met with Caltrans Assistant Structures Representative Roman Granados, at pier 7. The QAI noted that galvanized suspender shims have been delivered to the job site storage area and were not released to the job site. The QAI was asked to examine the parts to conduct a field release of the remaining shim plates. The QAI asked the contractor to un-stack the pallets so that each type of shim could be examined from the pallets. The QAI examined several shim plates from each pallet and noted that they appeared to be conforming to the contract requirements. The QAI confirmed with the QAI Leads Mike Foerder, Bill Levell and the Structural Materials Representative (SMR) Bahjat Dagher that a release will be performed at the job site. The QAI generated a TL-29 report with lot # B212-084-12 for the orange tag release of the remaining suspender shim plates. Reference the TL-29 for additional information.



### Summary of Conversations:

The QAI relayed the status of the document reviews and welding observations to the QAI Lead Bill Levell. The QAI also discussed the apparent condition of the suspender shim plates with the QAI Leads and the SMR. It was mutually agreed that the suspender shim plates could be released. Except as described above, there were no other notable conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, (510) 385-5910, who represents the Office of Structural Materials for your project.

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**Inspected By:** Croff,Scott

Quality Assurance Inspector

**Reviewed By:** Levell,Bill

QA Reviewer

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